

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015890**Date Inspected:** 22-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG components.				

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

ZPMC SHIP – 19: OBG Seg 8AW, Seg 8BW and Seg 8CW.

This QA Inspector along with Mr. Manikandan Murugan photographed and documented various locations of OBG Seg 8AW, Seg 8BW and Seg 8CW; prior to the shipment of Voyage 4 (en-route to Yerba Buena Island, California, USA). Photographs were taken and documented for the locations and are available for review upon request.

Details are as follows:

- OBG Seg 8AW - Panel Point (PP) 61 to PP64.
- OBG Seg 8BW – PP65 to PP67.
- OBG Seg 8CW – PP68 to PP71.

Photographs were taken and documented in the following sequence (starting from OBG Seg 8AW PP61 to Seg 8CW PP71):

- 1) Corner Assembly – Bike Path side.

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- 2) Longitudinal Diaphragm – Bike Path side.
- 3) Chevron diagonal members (upper and lower) – Bike Path side.
- 4) Sea fasteners.
- 5) Chevron diagonal members (upper and lower) – Cross Beam side.
- 6) Longitudinal Diaphragm – Cross Beam side.
- 7) Corner assembly – Cross Beam side.
- 8) Truss post – Cross Beam side.

The photographs and its sequence details are documented and are submitted to the Task Leader for review.

Trial Assembly:

Notification no: 006254.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components – Seg 9CE and Seg 9DE. The weld designations reviewed are as follows:

- 1) SP690-001 – 023 and 024.
- 2) SP545-001 – 035 and 036.
- 3) SP585-001 – 027, 028, 031 and 032.
- 4) BP180-001 – 053 and 054.
- 5) BP072-001 – 045 and 046.
- 6) EP146A-001 – 009 and 010.
- 7) DP698-001 – 015 and 016.
- 8) SP546A-001 – 042 and 043.
- 9) BP181-001 – 041 and 042.
- 10) BP073-001 – 033 and 034.
- 11) EP147A-001 – 009 and 010.
- 12) DP699A-001 – 009 and 010.
- 13) SP586-001 – 020, 021, 024 and 025.
- 14) SP691-001 – 023 and 024.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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